

**Work Order ID 64975**

Wednesday, January 05, 2011 11:27:01 AM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 1/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 1-4-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control!

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

1/1/10 sf 50

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64975**

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Page 2

Item ID: D350-578-011

Accept



Setup Start



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Item Name: Bearpaw

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Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 □ Location: 11

Reo A

11/1/17

SP

(5X)

190

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/01/18

ME

11-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, January 05, 2011 11:27:05 AM

Page 1

Work Order ID: 64975

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-01-02 JLM  
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A Bolt		Purchased	No			160	Each	518.0000	12	48 10x			
-----------------	--	-----------	----	--	--	-----	------	----------	----	--------	--	--	--

Location Loc Qty Loc Code

ST358 500

116400 100

116419 400

ST359 18

112314 18

D2182B Rubber Cushion		Manufactured	No			160	f	234.7960	2.5	10			
--------------------------	--	--------------	----	--	--	-----	---	----------	-----	----	--	--	--

Location Loc Qty Loc Code

ST410 234.796

63413 234.796

D2274 Radius Block		Manufactured	No			160	Each	198.0000	12	148			
-----------------------	--	--------------	----	--	--	-----	------	----------	----	-----	--	--	--

Location Loc Qty Loc Code

ST010 198

61361 1

63990 11

64420 186

D2432 206 (24") Bearpaw		Manufactured	No			160	Each	0.0000	2	8 10			
----------------------------	--	--------------	----	--	--	-----	------	--------	---	------	--	--	--

5/5

8/5

5/5

5/5

3

11/1/10 SP

50

11/1/10 SP

12.300

11/1/10 SP

24x B6477

11/1/10 SP

39

64299

11/1/10 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Wednesday, January 05, 2011 11:27:05 AM

Page 2

Work Order ID: 64975

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

D2438

Manufactured No

160

Each

101.0000

6

24



Clamp



11/11/10

85

## Location

## Loc Qty

## Loc Code

ST256

100

63999

100

ST456

1

60852

1

30

D2529

Manufactured No

160

Each

924.0000

12

48



Washer



11/11/10

64

## Location

## Loc Qty

## Loc Code

ST017

924

64127

924

60

MS21042L4

Purchased No

160

Each

4,180.000

12

48



Nut



11/11/10

64

## Location

## Loc Qty

## Loc Code

ST300

4180

1123143

2

115589

10

115621

668

116188

3500

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

160

Each

3,451.000

24

96



Washer



11/1/10 sl (50)  
m116304 (92x)

Location

Loc Qty

Loc Code

ST297

2800

116304

2800

ST298

651

110914

4

115622

38

116025

118

116289

491

~~98~~  
28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

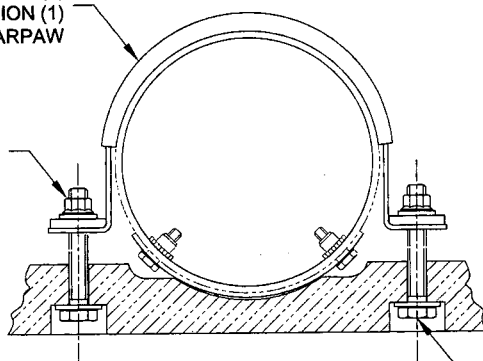
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

D2438 CLAMP (1)  
D2182B050 RUBBER CUSHION (1)  
3 PL PER BEARPAW

MS21042L4 NUT (1)  
AN960JD416 WASHER (1)  
D2274 RADIUS BLOCK (1)  
D2529 WASHER (1)  
AN4-17A BOLT (1)  
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

## Section A-A

Figure 4 - Clamping Detail

## 5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F

Date: 08.08.28